

Date: Thursday, 20/11/2008 3:11:53 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : ASPIRATOR
Job Number : 43571	
Estimate Number : 12424	
P.O. Number :	Part Number : D2000109
This Issue : 20/11/2008 S.O. No. :	Drawing Number : D2000-109 REV A1
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : PURCHASED PARTS	Drawing Revision : A1
Previous Run : 35321	Material :
Written By :	Due Date : 21/12/2008 Qty: 10 Um: Each
Checked & Approved By : <u>JLD 08/11/21</u>	
Comment : Est Rev:A New Issue 06-05-31 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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**Comment:** PURCHASINGIssue P/O: 7655 For D2000-109

Spin as per Dwg D2000-109

Possible Supplier: SIEG

Material release note is required

C208/11/24

(10)

2.0	D2000109S	Aspirator- Outer Flange
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure material certification is attached

R 08/11 (10)

4.0	QC6	DIMENSIONAL CHECK
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**Comment:** DIMENSIONAL CHECKS 08/12/12 (10)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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**Comment:** SMALL & MEDIUM FAB RESOURCE 1

Drill as per Dwg D2000

Deburr

FF 09-01-06

(10)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: ASPIRATOR

Job Number: 43571

Part Number: D2000109

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/4/66 (x10)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: S7170

P 9/01/8 (10)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



(10)

Comment: FINAL INSPECTION/W/O RELEASE

H 09/6/08
MF 09-01-08

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

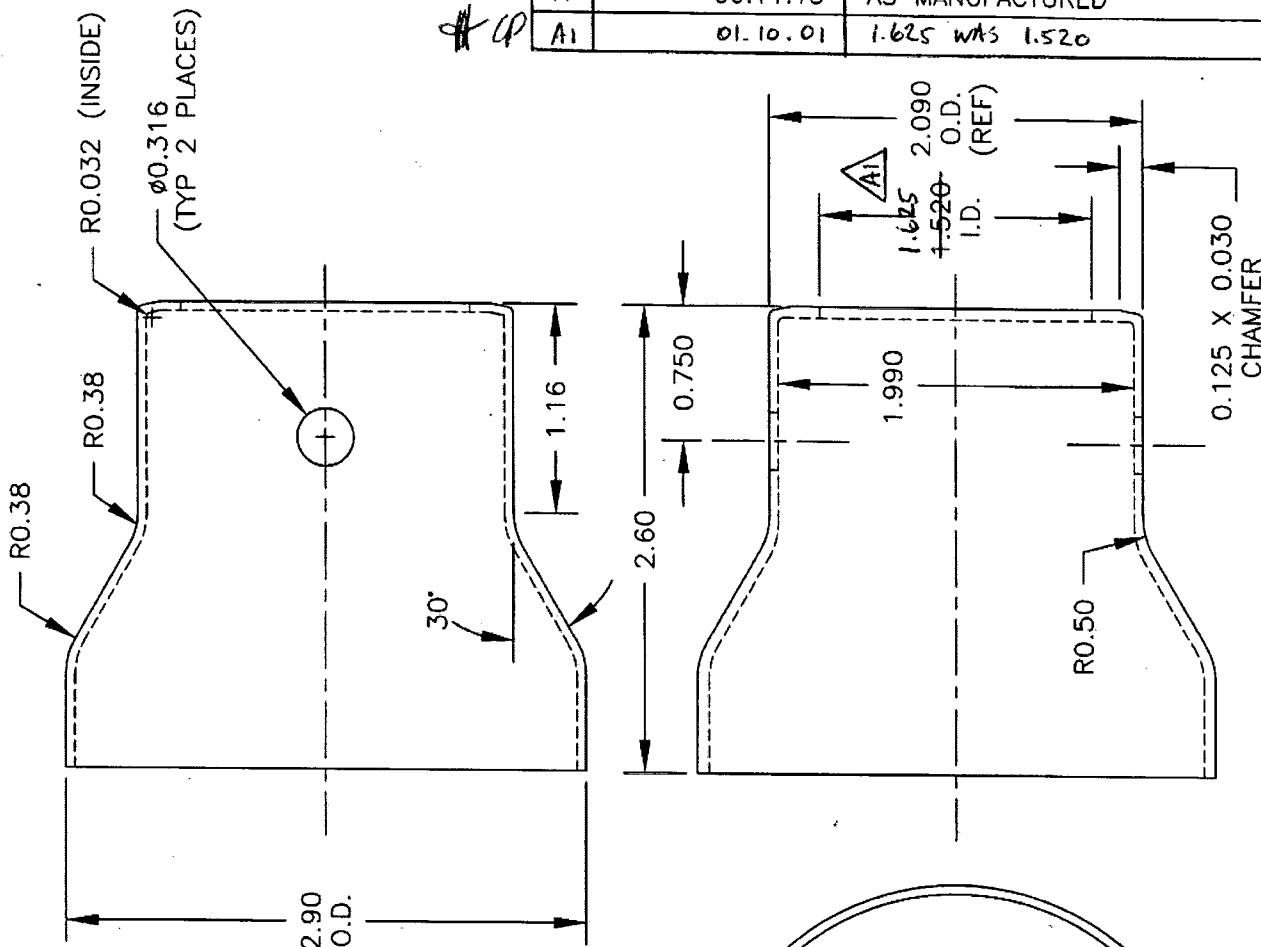
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

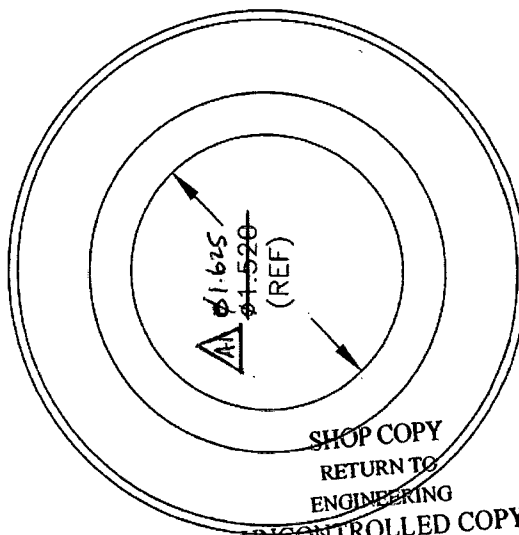
NOTE: Date & initial all entries



DESIGN	JB	DRAWN BY	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	JP	APPROVED	JP	DRAWING NO. D2000-109	REV. A SHEET 1 OF 1
DATE	00.11.13			TITLE ASPIRATOR	SCALE 1:1
A	00.11.13			AS MANUFACTURED	
A1	01.10.01			1.625 WAS 1.520	



RELEASED
00 11 20 JP



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NOTES:
THIS PART MUST MATE WITH D2000-111
MATERIAL: 1100-0 ALUMINUM (QQ-A-250/1) 0.063 THICK
FINISH: NONE
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Sieg's Manufacturing Ltd.

Metal Spinning and Fabricating

6236 - 205 STREET, LANGLEY, B.C. V2Y 1N7

TELEPHONE: (604) 530-7455 • FAX: (604) 530-7490

INSPECTION REPORT

Date: 12/10/08

Customer: Dart Aerospace

Packing Slip: 36124

S
60/12/12

Part#	Quantity	Material	Check holes	Debur edges	Insp. By
D2000109S	10	14G	✓	✓	12
D2000111S	10	14G.	✓	✓	12
D2060S	20	14G	✓	✓	12
D2061P	20	14G	n/a	✓	12

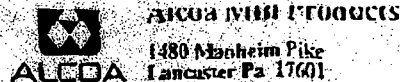
Notes:

PO# 7655

12/12/11

Material Certification Attached: Yes ~~12~~

UTM. KERRY



Certification of Test Results

P/N 970200

PO 38C880

CERT NO 3000675396
DATE 4/23/2007
SKID NO 661032
SKID WGT 9.885
PAGE 1 OF 1

SOLD TO

SHIP TO

ORDER NO	LG5947	PO NO	43-62756			MILL FINISH
ITEM NO	1	PART NO				NON ANODIZE QUALITY
ALLOY	A100	TEMPER	O	FORM	COIL	OUT: STANDARD MILL FINISH
GUAGE	.06300	WIDTH	48.0000	LENGTH	0.0000	IN: STANDARD MILL FINISH
						NOT EMBOSSED

LOT: 314171 COIL: B02 DROP: 07T0187

INGOT	SI	FE	CU	MN	MG	CR	NI	ZN	TI
*U718321	0.12	0.49	0.12	0.02	0.01	0.02	0.01	0.01	0.01

HEAD ULTIMATE STRENGTH 13.1 KSI
TAIL ULTIMATE STRENGTH 13.0 KSI
HEAD YIELD STRENGTH (OFFSET = .2%) 5.5 KSI
TAIL YIELD STRENGTH (OFFSET = .2%) 5.3 KSI
HEAD ELONGATION (G.L. = 2 IN) 32 %
TAIL ELONGATION (G.L. = 2 IN) 31.5 %

* AS REPORTED BY SUPPLIER
MECHANICAL PROPERTIES ACCORDING TO ASTM B-557-06

MECHANICAL AND CHEMICAL PROPERTIES MEET THE REQUIREMENTS OF:
ASME SB209 1100 C, AMS 4001H 1100 O,
ASTM B209-06 1100 O, AMS-QQ-A-250/1 1100 O
PAX CERTS: 714-736-4840

** END OF CERTIFICATION **

We hereby certify that, unless otherwise indicated, the material covered by this report has been manufactured, inspected, and tested in accordance with, and has been found to meet, the applicable requirements described herein, including any specifications forming a part of the description and that samples representative of the material met the composition. Also, note that mercury is not a normal contaminant in aluminum alloys and neither it nor any of its compounds are used in the manufacture of our product. Certification of test results shall not be reproduced except in full.

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Authorized By: JEFF KREADY, LAB SUPERVISOR

Sold to: COPPER & BRASS SALES PO: 38C880 Part: Order No.: 376276

TR clerk signature: *[Signature]*